

RB KIT 407M-11
Job Sheet 171581

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200



Part No: RB KIT 407M-11

Job Qty: 6 pcs

MAR 1 6 2018

DAS
13
9-89

Priority: Medium

Status: Scheduled

Job Tracking No:

Created By: Marie Lafunesse

Description:

Ship Via:

Type: Stock

Due Date: 2/9/18

Job Created: 2/5/18

Part Weight: 0 lbs

Part Name: Gauge Pin



S052172

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Setup Run Hrs	Workcenter/Supplier	
						Standard	Lead Time
90	Start up Operation	6 Ea	2/9/18	0.00	0.00	Start Up Container	Sign-off
100	Outsource	6 pcs	2/9/18	0.00	0.00	Outsource16	AT 18/03/21
110	Packaging	6 pcs	2/9/18	0.00	0.00	Packaging2	AT 18/03/21
120	QC	6 pcs	2/9/18	0.00	0.00	QC6	AT 18/03/21
130	Packaging	6 pcs	2/9/18	0.00	0.00	Packaging3	MAR 23 2018
140	QC	6 pcs	2/9/18	0.00	0.00	QC21	CH-01

Part Op 100 - 1-Issue P/O to KG Grinding: P/O 037202 (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3-Descriptions: Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	100-Outsource	Container
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GM20-192

Gauge Pin 0.0960

6 (1 ea)

100-Outsource

5044659

6-118-1728

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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GM20-192

6

0

Inventory

0

3 p/m

Part Specifications

Specifications could not be found.

Plex 2/5/18 11:54 AM Dart.lafunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

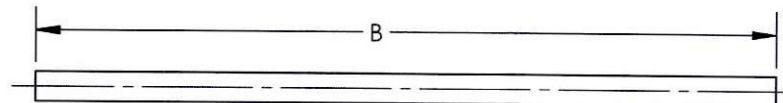
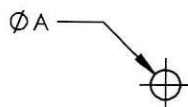
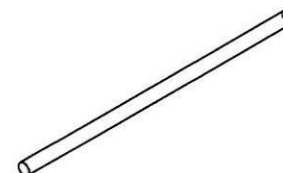
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																															
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																													
Description Work Order Deviation		Job No: 171581 Mfg Date: 03/16/18 Packaging Change No: Operation: Revision: SERIAL NO/BATCH: S052172 PART NO: RB KIT 407M-11 Gauge Pin .0960" dia. 																																															
		Completed By		Lead hand / Supervisor Approval Verification																																													
		QC / QA Coordinator Approval																																															
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td>☐ Positioned Wrong</td> <td>☐ Cut or Sequence</td> </tr> <tr> <td>☐ Outside Dimensions</td> <td>☐ Off-set</td> </tr> <tr> <td>☐ Over/Under tolerance</td> <td>☐ Mislabeled</td> </tr> <tr> <td>☐ Part Incorrect</td> <td>☐ Fit/Function</td> </tr> <tr> <td>☐ Part Lost/Missing</td> <td>☐ Misaligned/off center</td> </tr> <tr> <td>☐ Part Moved</td> <td></td> </tr> <tr> <td>☐ Drawing</td> <td></td> </tr> <tr> <td>☐ Finish</td> <td></td> </tr> <tr> <td>☐ Misread</td> <td></td> </tr> <tr> <td>☐ Turning Sequence</td> <td></td> </tr> </table>				☐ Positioned Wrong	☐ Cut or Sequence	☐ Outside Dimensions	☐ Off-set	☐ Over/Under tolerance	☐ Mislabeled	☐ Part Incorrect	☐ Fit/Function	☐ Part Lost/Missing	☐ Misaligned/off center	☐ Part Moved		☐ Drawing		☐ Finish		☐ Misread		☐ Turning Sequence	
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☐ Turning Sequence																																																	
OTHER : _____		☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Cut Too Short																																															

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0085	-01 THRU -31 ADDED GAUGE PIN DIMENSIONS TABLE.	4/6/2017	RJC	JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171581M-5
180205



GUAGE PIN DIMENSIONS

PART NUMBER	ØA	B
-01	(Ø.0240)	1"
-03	(Ø.0400)	1"
-05	(Ø.0540)	1"
-07	(Ø.0600)	1"
-09	(Ø.0800)	1"
-11	(Ø.0960)	1"
-13	(Ø.1080)	1"
-15	(Ø.1200)	1"
-17	(Ø.1440)	1"
-19	(Ø.1440)	1/4"
-21	(Ø.1600)	1"
-23	(Ø.1600)	1/4"
-25	(Ø.1728)	1"
-27	(Ø.1728)	1/4"
-29	(Ø.1800)	1"
-31	(Ø.1920)	1"

-01 THRU -31
GUAGE PIN

DART AEROSPACE	
TITLE SPLINE MEASURING KIT ASSY	
DWG NO. RB KIT 407M-01 THRU -31	REV 2
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	BELL 407
SCALE 4:1	DATE 12/7/2016 SHEET 2 OF 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐											



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039202

Supplier: AFF001-VC
Affutage K.G. Inc.
11455 Philippe Panneton Ave.
Montreal
QC
H1E 4M1 Canada
Phone: 514 323 0192 514 323 6631
Fax: 514 323 6631

PO No: PO039202

PO Date: 3/5/18

Due Date: 3/14/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

REVISED

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170734	RBST4241-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009	Firmed	3/14/18	6 pcs	0 pcs 6x	6 pcs AT	\$12.00/pcs	\$72.00
2	173095	RBST2854-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 1 pin make 4 pcs	Firmed	3/14/18	26 pcs	0 pcs 26x	26 pcs	\$12.00/pcs	\$312.00
3	170733	RBST1016-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009	Firmed	3/14/18	6 pcs	0 pcs 6x	6 pcs	\$12.00/pcs	\$72.00
4	171045	RBST1007-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 1 pin make 3 pcs	Firmed	3/14/18	6 pcs	0 pcs 6x	6 pcs	\$12.00/pcs	\$72.00
5	RB KIT 407M-09	Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	3 pcs	0 pcs 3x	3 pcs	\$12.00/pcs	\$36.00	

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	171579	RB KIT 407M-07	Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	3 pcs	0 pcs	3 pcs	\$12.00/pcs	\$36.00
7	171585	RB KIT 407M-15	Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	3 pcs	0 pcs	3 pcs	\$12.00/pcs	\$36.00
8	171588	RB KIT 407M-23	Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 6 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	6 pcs	0 pcs	6 pcs	\$12.00/pcs	\$72.00
9	171587	RB KIT 407M-21	Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	4 pcs	0 pcs	4 pcs	\$12.00/pcs	\$48.00
10	171577	RB KIT 407M-05	Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	3 pcs	0 pcs	3 pcs	\$12.00/pcs	\$36.00
11	171581	RB KIT 407M-11	Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	3 pcs	0 pcs	3 pcs	\$12.00/pcs	\$36.00
12	172345	RB KIT 407M-17	Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	2 pcs	0 pcs	2 pcs	\$12.00/pcs	\$24.00

Plex 3/16/18 8:50 AM dart.lavoie.chanta

AFFUTAGE K.G. INC. K.G. GRINDING INC.

40 ans
Depuis 1975

11455 Ave. Philippe Panneton
Montréal, Québec
Canada, H1E 4M1
Tél. : 514-323-0192
Fax : 514-323-6631

Distributeur d'outils de coupe & Affutage sur mesure

Distributor of cutting tools & Custom tooling

BON DE LIVRAISON DELIVERY SLIP

DATE: MAR-14-2018

DART AEROSPACE

73005

P.O. # 39202

QTÉ	LIVRÉE	B/O	DESCRIPTION	PRIX UNITAIRE	TOTAL
6	(6)	-	RBST4241-5		
26	(26)	-	RBST2854-5		
6	(6)	-	RBST1016-5		
6	(6)	-	RBST1007-5		
3	(36)	-	RB KIT 407M-09		
3	(36)	-	" " - 07		
3	(36)	-	" " - 15		
6	(7)	-	" " - 23		
4	(4)	-	" " - 21		
3	(36)	-	" " - 05		
3	(36)	-	" " - 11		
2	(2)	-	" " - 17		
				SOUS-TOTAL	
				TPS	
				TVQ	
				TOTAL:	

REÇU EN BONNE CONDITION / RECEIVED IN GOOD ORDER

www.kggrinding.com • sales@kggrinding.com